

Date:  
User:Wednesday, 4/5/2006 3:33:33 PM  
Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STA 84 BRACKET
Job Number	: 26588		
Estimate Number	: 11035	Part Number	: D28032
P.O. Number	: <i>NIA</i>	Drawing Number	: D2803 REV B
This Issue	: 4/5/2006	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: B
First Issue	: <i>NIA</i>	Material	: <i>NIA</i>
Previous Run	: 25929	Due Date	: 4/24/2006
Written By	: <i>SEE COMMENT BELOW</i>	Qty:	10 Um: Each
Checked & Approved By	: <i>06.04.06</i>		
Comment	: Est. A 00.11.06 New Issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X10000	6061-T6 Bar .50" x 10.0"
Comment: Qty.: 2.0125 f(s)/Unit Total: 20.1254 f(s) 6061-T6 Bar .50" x 10.0" Material: 6061-T6 bar 10.00" x 0.50" Batch: <i>M100742 X8</i> <i>06/04/25</i> 10		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks per template DT8533 <i>06/04/25</i> 10		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA102 <i>06/04/26</i> 10		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>06/04/26</i> 10		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK <i>5.6 06/04/27</i> 10		
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble & Deburr <i>06/04/26</i> 10		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 22/05/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 84 BRACKET

Job Number: 26588

Part Number: D28032

Job Number:



Seq. #:	Machine Or Operation:	Description :
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7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*M.F. 06-03-01*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

*SB 04/05/02*

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*SB 06/05/04 (10)*

Job Completion



*u 06/05/04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>26588</b>
<b>Description:</b> Bracket		<b>Part Number:</b>	<b>D2803-2</b>
<b>Inspection Dwg:</b> D2803	<b>Rev:</b> B	<b>Page 1 of 1</b>	

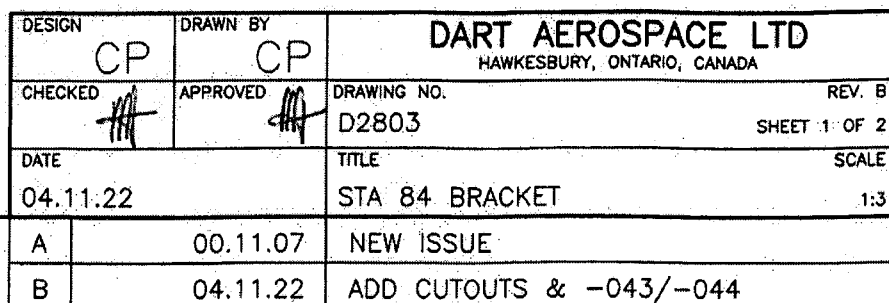
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

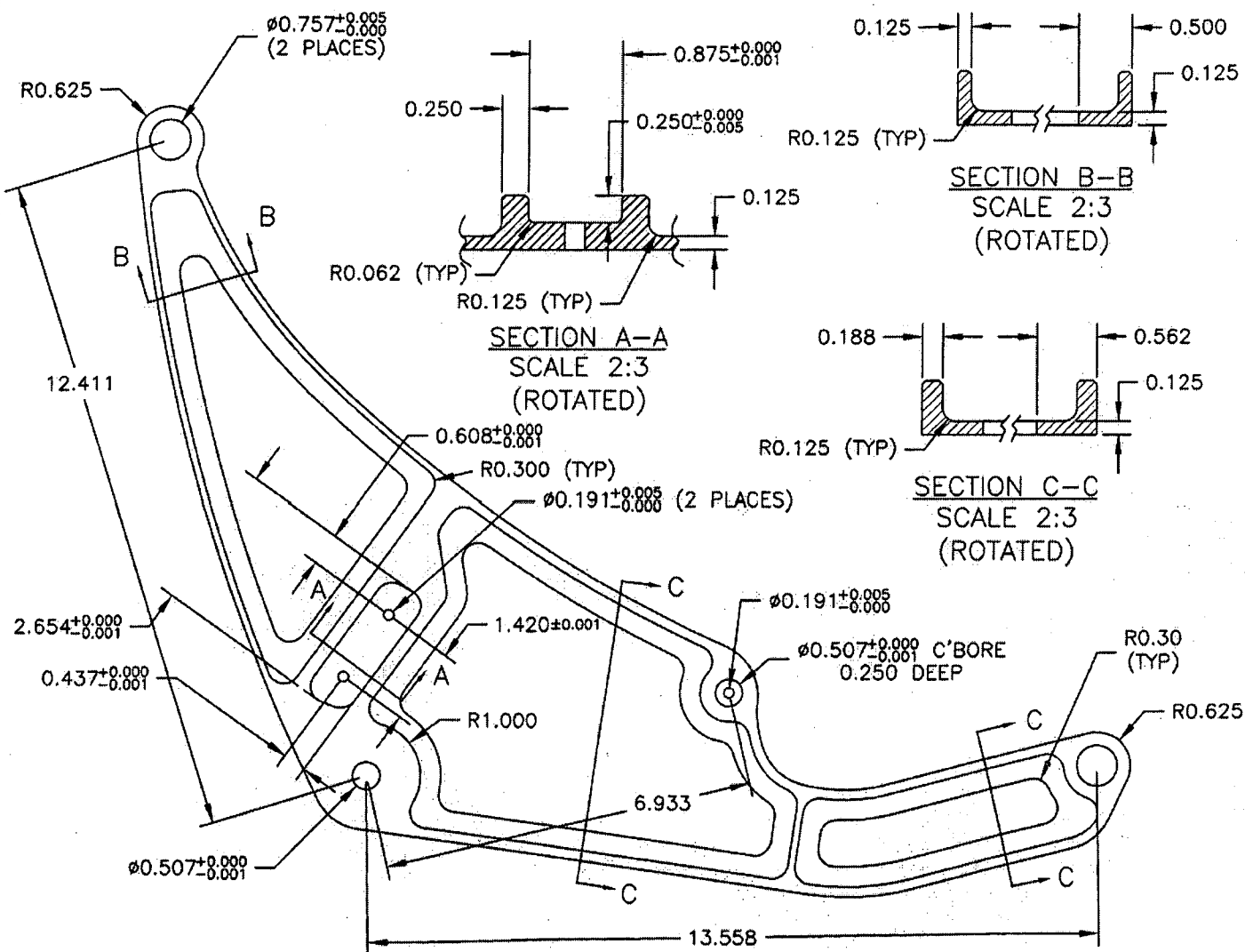
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	Ø0.761	✓			
1.420	+/-0.001	1.419	✓			
Ø0.191	+0.005/-0.000	Ø0.191	—			
Ø0.507	+0.000/-0.001	Ø0.507	—			
Ø0.507 x 0.250	+0.000/-0.001	Ø0.507x0.250	—			
12.411	+/-0.010	12.408	—			
13.558	+/-0.010	13.558	—			
6.933	+/-0.010	6.930	—			
0.250	+/-0.010	0.249	—			
0.875	+0.000/-0.008	0.8747	—			
0.250	+0.000/-0.005	0.247	—			
0.125	+/-0.010	0.127	✓			
0.125	+/-0.010	0.120	—			
0.500	+/-0.010	0.506	—			
0.125	+/-0.010	0.128	—			
0.188	+/-0.010	0.190	✓			
0.562	+/-0.010	0.562	—			
0.125	+/-0.010	0.122	—			

<b>Measured by:</b>	<i>mk</i>	<b>Audited by:</b>	<i>En</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	06/04/26	<b>Date:</b>	06/04/26	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	<i>[Signature]</i>



05.03.11



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WITHOUT NOTICE  
WORK ORDER  
NO 26588

D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

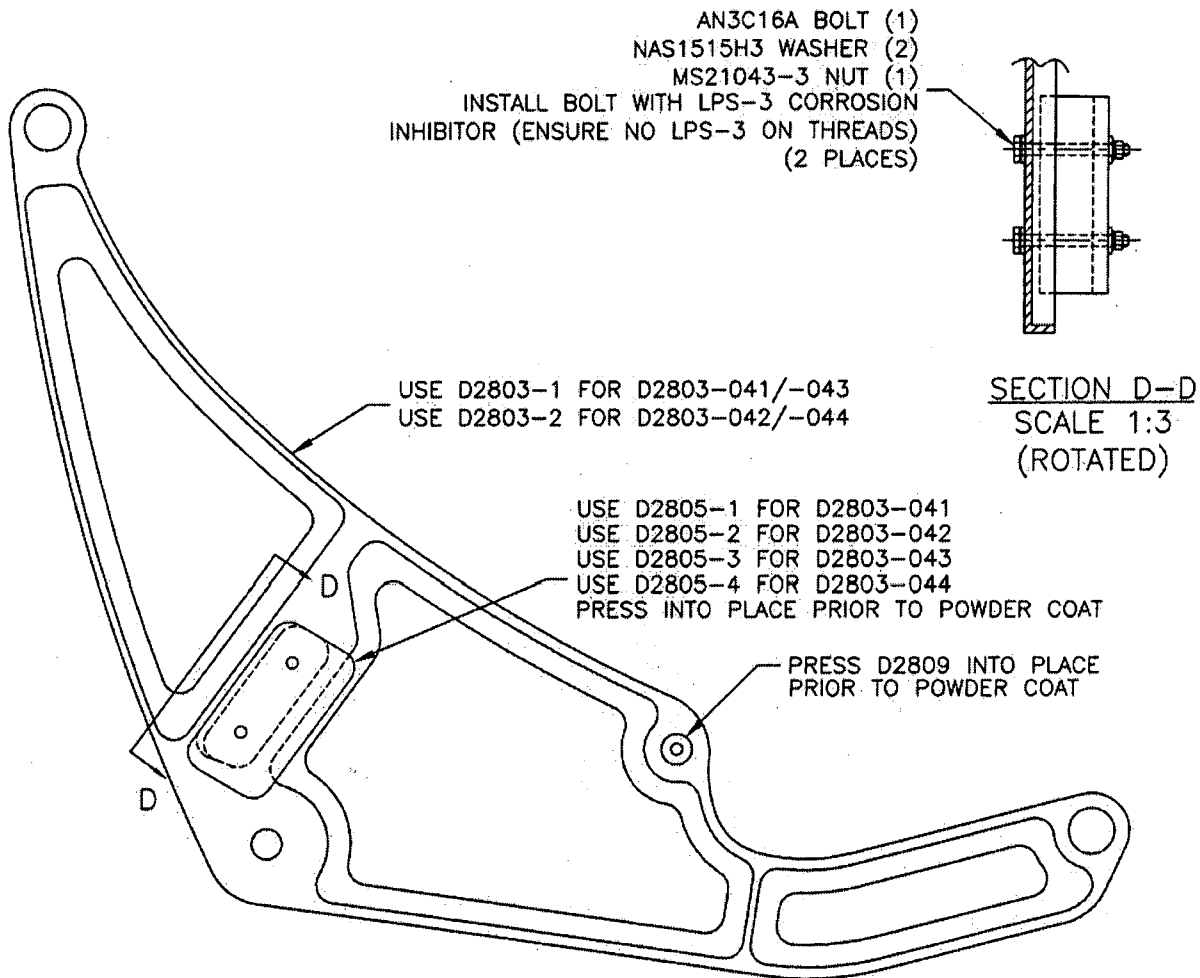
- 1) MACHINE PER DRAWING FILE "D2803.SLDPR1"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



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05-03-11 SUBJECT TO AMENDMENT  
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WORK ORDER  
NO. 26588

D2803-041/-043 BRACKET ASS'Y (SHOWN)  
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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